

Work Order ID 146825

Tuesday, May 24, 2016 9:55:37 AM

146825

U/R

FOR BELL

Page 1

Item ID: D412-761-045

Revision ID: URF-16-533

Item Name: Bubble Window

Start Date: 6/17/2016 Start Qty: 2.00

Required Date: 6/23/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr		DAS						
IIN D412-761	Rev E U/R	OK	6	9-89					

100	Document Control	0.00							
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100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D412-761-045 CHG002

JUL 11 2016
See attachment

DAS
27
9-89

DAS
21
9-89

JUL 13 2016

110	Pick Kit	0.00							
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110

Packaging

Packaging

Memo

0.00

DAS
6
9-89

JUL 11 2016

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Quality Control

Memo

0.06

DAS
27
9-89

JUL 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 					
Description Work Order Deviation				Disposition								
								Completed By				
								Lead hand / Supervisor Approval Verification				
								QC / QA Coordinator Approval				
Root Cause		FAULT CATEGORY										
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐							
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐							
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐							
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐							
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐							
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐							
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐							
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____										
Misidentified ☐	Past Due ☐											

Work Order ID 146825

Tuesday, May 24, 2016 9:55:37 AM

146825

Page 2

Item ID: D412-761-045

Accept

N900040100Setup Start ***NS1***

Revision ID: URF 16-533

Stop ***NS2***

Item Name: Bubble Window

Start Date: 6/17/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-761-045

Location: _____

PPP Rev: _____

PPP148386

JUL 13 2016

DAS
27
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

DAS
21
9-89

JUL 14 2016

Su 7/13/16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B
13.01.15 as per ECN13-511 DD Verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3704-3 ; *D3704-3* Escutcheon		Manufactured	No			110	Each	1.0000	1	148/33			68-6 9 SW
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST052	1							
						1							
NAS43DD3-24 *NAS43DD3-24* Spacer for both		Purchased	No			110	Each	44.0000	1				68-6 9 SW
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST550	44							
					M128454	44							
D412-761-043 *D412-761-043* Modified Latch Mechanism, LH		Manufactured	No			110	Each	0.0000	1	146935			68-6 9 SW
D3676-1 *D3676-1* Bubble Window, LH		Manufactured	No			110	Each	0.0000	1	B146805			68-6 9 SW
D3678-1 *D3678-1* Placard		Manufactured	No			110	Each	7.0000	1	146805			68-6 9 SW
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST051	7							
					139501	2							
					145256	5							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
										QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

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Page 2

Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

D3678-3

Manufactured No

110

Each

7.0000

1

D3678-3

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

7

139556

2

145257

5

**

68-6

9

DAS

D3700-1

Manufactured No

110

Each

4.0000

1

D3700-1

Inboard Window Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

ST051

4

112422

2

113719

2

**

68-6

9

DAS

D3700-3

Manufactured No

110

Each

1.0000

1

D3700-3

Outboard Window Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

1

113793

1

**

68-6

9

DAS

D3701-1

Manufactured No

110

Each

3.0000

1

D3701-1

Floor Doubler

DAS
27
9-89

Location

Loc Qty

Loc Code

st239

3

96231

3

**

68-6

9

DAS

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Tuesday, May 24, 2016 9:55:37 AM

Page 3

Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

D3702-1	Manufactured	No	110	Each	2.0000	1
---------	--------------	----	-----	------	--------	---

D3702-1

Fwd Doubler

DAS
27
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

st507	2	
110312	2	

**

146922

68-6
9
SVD

D3703-1	Manufactured	No	110	Each	8.0000	1
---------	--------------	----	-----	------	--------	---

D3703-1

Aft Doubler

DAS
27
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST512	8	
113680	8	

**

68-6
9
SVD

D3703-3	Manufactured	No	110	Each	6.0000	1
---------	--------------	----	-----	------	--------	---

D3703-3

Aft Corner Doubler

DAS
27
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

st239	6	
112397	2	
113705	3	
144512	1	

**

148973

JUN 17 2016

68-6
9
SVD

D3703-5	Manufactured	No	110	Each	1.0000	1
---------	--------------	----	-----	------	--------	---

D3703-5

Aft Cap

DAS
27
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST052	1	
112542	1	

**

146016

68-6
9
SVD

ADDED D3678-5 x 1 B 148033

DAS
27
9-89

W-ECN 16-599
MF

DAS
6
9-89

JUL 12 2016

Tuesday, May 24, 2016 9:55:37 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

Picklist Print

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Page 4

Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

D3704-1	Manufactured	No	110	Each	2.0000	1				
D3704-1										
Escutcheon										
DAS 27 9-89										
D3708-1	Manufactured	No	110	Each	2.0000	1				
D3708-1										
Angle										
DAS 27 9-89										
D3708-3	Manufactured	No	110	Each	2.0000	1				
D3708-3										
Angle										
DAS 27 9-89										
D3709-1	Manufactured	No	110	Each	1.0000	1				
D3709-1										
Angle										
DAS 27 9-89										
D3709-3	Manufactured	No	110	Each	0.0000	1				
D3709-3										
Angle										
DAS 27 9-89										

Tuesday, May 24, 2016 9:55:37 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Description Work Order Deviation				Disposition							
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Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Picklist Print

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Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

D3802-1

Manufactured No

110 f

144.1378 13.5

D3802-1

Windows Seal (\$ Per Foot)

**

147067

DAS
38
9-89

Location

Loc Qty

Loc Code

ST416

144.13776

134091

0.75

140492

1

141991

5.88776

143804

36.5

145243

50

146267

50

DT9458

Manufactured No

110 Each

0.0000

DT9458

Cutting Template

DAS
27
9-89

**

AN3-7A

Purchased No

110 Each

256.0000

AN3-7A

Bolt

**

Location

Loc Qty

Loc Code

over003

250

m134606

250

ST3349

1

m133694

1

ST349

5

m132803

5

DAS
27
9-89

JUL 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

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Page 6

Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

110

Each

1,799.000

52

104

NAS1149D0363.J

Washer

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST260a

1000

m134676

1000

ST263

334

m134606

334

52

MS21042L3

Purchased

No

110

Each

1,619.000

26

MS21042L3

Nut

**

134943

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

242

m133790

3

m134360

239

ST303

1277

m134039

12

m134360

65

m134634

600

m134754

600

MS24694-C5

Purchased

No

110

Each

100.0000

1

MS24694-C5

Screw

**

DAS
6
9-89

JUL 12 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST285

100

m130238

100

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Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐				
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval			
Description Work Order Deviation				Disposition						
										Completed By
										Lead hand / Supervisor Approval Verification
										QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY								
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐					
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐					
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐					
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐					
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐					
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐					
Past Expiry Date ☐	Manufacturing Process ☐									
Misidentified ☐	Past Due ☐	OTHER :								

Picklist Print

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Work Order ID: 146825

146825

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Bubble Window

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 2.00

Required Qty: 2.00

MS24694-C13

Purchased

No

110

Each

13.0000

MS24694-C13

Screw

**

1

2

Location

Loc Qty

Loc Code

ST285

13

108558

13

DAS
27
9-89

DAS
6
9-89
JUL 12 2016

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Shop Packet Print

Page 7

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QS1042) Approval ☐
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Description Work Order Deviation 	Disposition 	Completed By _____
		Lead hand / Supervisor Approval Verification ☐
		QC / QA Coordinator Approval ☐

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Work Order ID 146825

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146825

U/H

Page 1

Item ID: D412-761-045

Accept

N900040100

Setup Start ***NS1***

Revision ID: URF-16-533

Stop ***NS2***

Item Name: Bubble Window

Start Date: 6/17/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start ***NR1***

QC: *[Signature]*

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	Rev E U/R OK	<i>UP 16/5/31</i>							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-045								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

JUL 11 2016

DAS
21 JUL 12 2016
9-89

(2)

see attachment

DAG
6
9-89

JUL 11 2016

-4-

[illegible]